

Work Order ID 81052

81052

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March-07-12 2:23:18 PM

Item ID: D2435

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw, 206

Start Date: 07/03/2012 Start Qty: 20.00 ***20***

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 20.00 ***20***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/03/07 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation: Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2435	Rev E1

120 0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

12-03-23 (10)

130 0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435 JL 12-04-25
3-Deburr

(10)

140 0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

JL 12-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC8- Inspect parts - second check

0.00

150

12.4.26

10

1

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location:

0.00

151

PPP 8/047

0.00

Packaging

Memo

Packaging

12/5/11 *10*

190

QC21- Final Inspection - Work Order Release

0.00

190

12/5/11 *28*

QC

Memo

0.00

Quality Control

MF
12-05-01

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Picklist Print

March-07-12 2:23:22 PM

Page 1

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Parent Item: D2435

D2435

Parent Item Name: Bearpaw, 206

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

573.6043

3.2

64

MUHMWB10

**

UHMW 1" Black

for mm

B. 2-4-06

Location

Loc Qty

Loc Code

MAT018

316.48

120035

74.48

120401

242

MAT019

257.1243158

117321

74.6

117738

93.28

117819

83.3

118814

1.5

119145

4.44431579

120401

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DART AEROSPACE LTD		Work Order:	81052
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.07 x 45°	✓		Vern	SL-10
B	5.500	+/-0.030	5.501	✓		~	
C	0.200	+/-0.030	.199	✓		~	
D	R0.250	+/-0.030	.250	✓			
E	0.250	+/-0.010	.248	✓		~	
F	0.625	+/-0.030	.623	✓		~	
G	0.25 x 45°	+/-0.030	.24 x 45°	✓		~	
H	.0.375	+/-0.010	.374	✓		~	
I	19.000	+/-0.030	19.00	✓		m-type	
J	0.950	+0.030/-0.010	.946	✓		Vern	SL-10
K	Ø0.260	+0.005/-0.000	.260	✓		~	
L	Ø0.930	+/-0.030	.930	✓		~	
M	0.30	+0.030/-0.000	.311	✓		~	
N	0.375	+/-0.030	.374	✓		✓	
O	7.375	+/-0.030	7.343	✓		H-G	
P	4.250	+/-0.010	4.250	✓		Vern	SL-10
Q	2.000	+/-0.030	2.010	✓		"	
R	9.000	+/-0.010	9.000	✓		H-G	
S	15.750	+/-0.030	15.450	✓		m-type	

Measured by:	SL	Audited by:	22	Prototype Approval:	N/A
Date:	12-04-24	Date:	12-4-26	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF 17	17

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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED KE	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

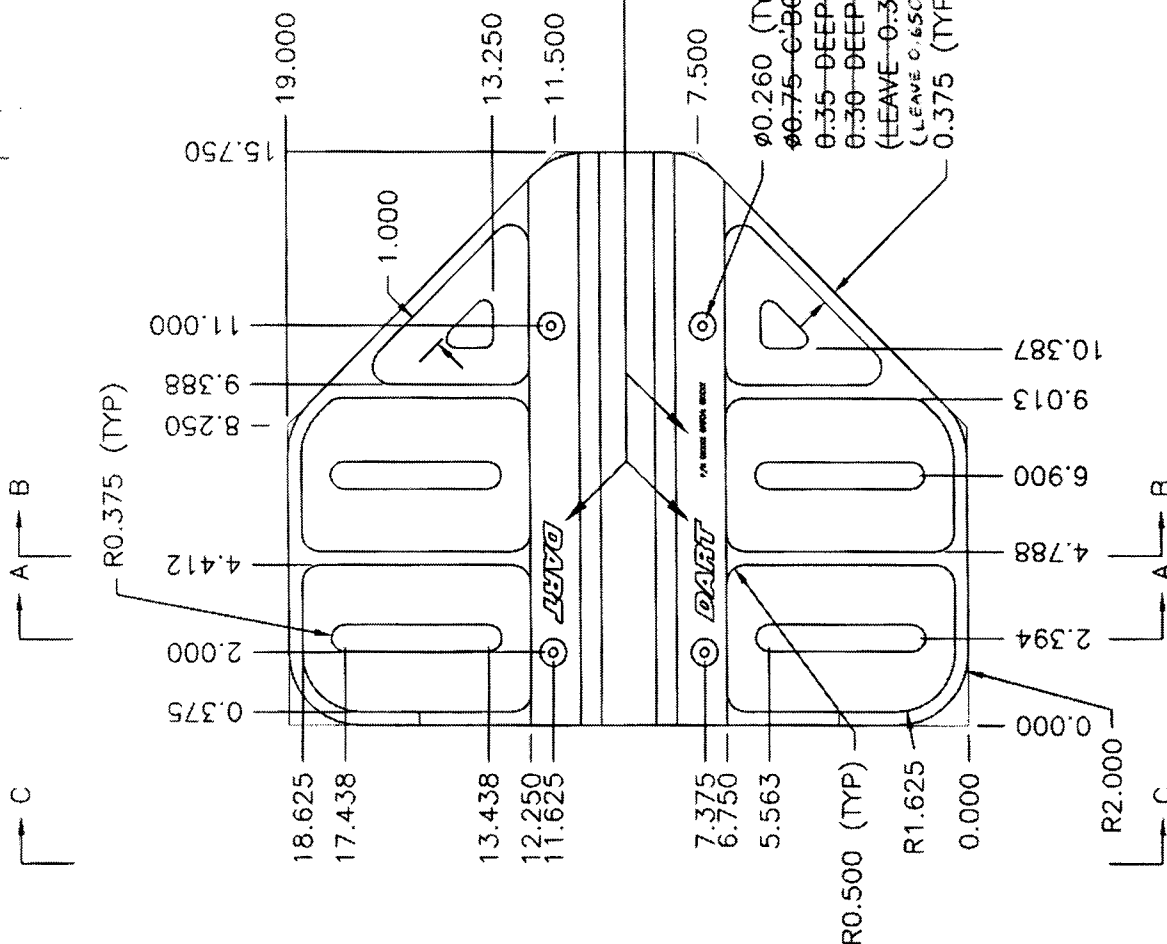
RELEASED
98.06.17 KE

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81052463
12/03/07

EFFECTIVE DEOS

9143	



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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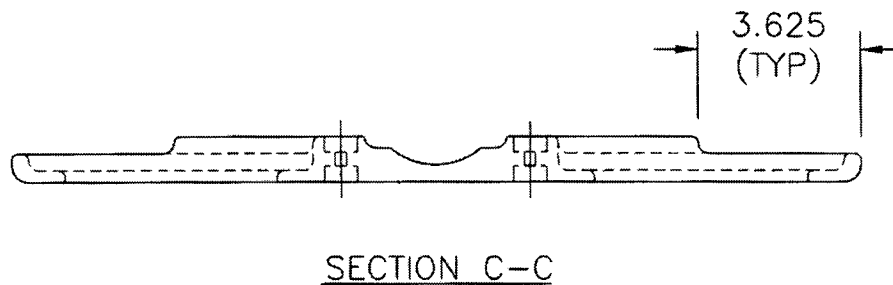
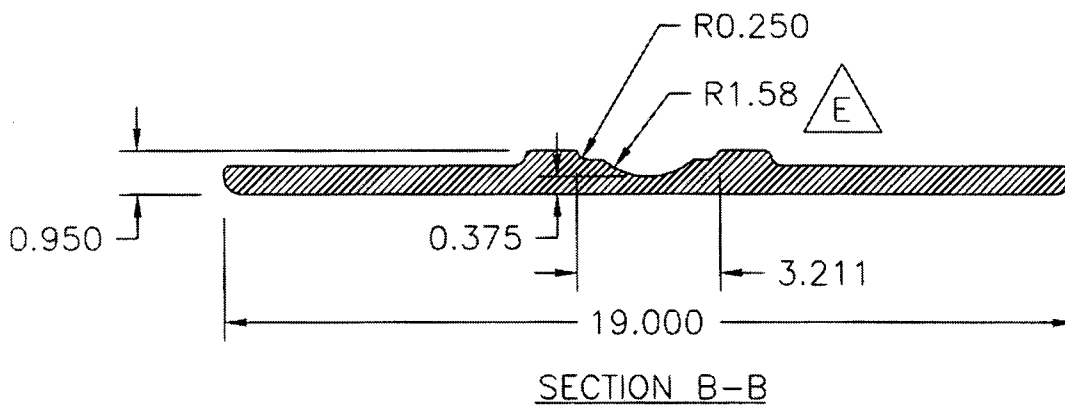
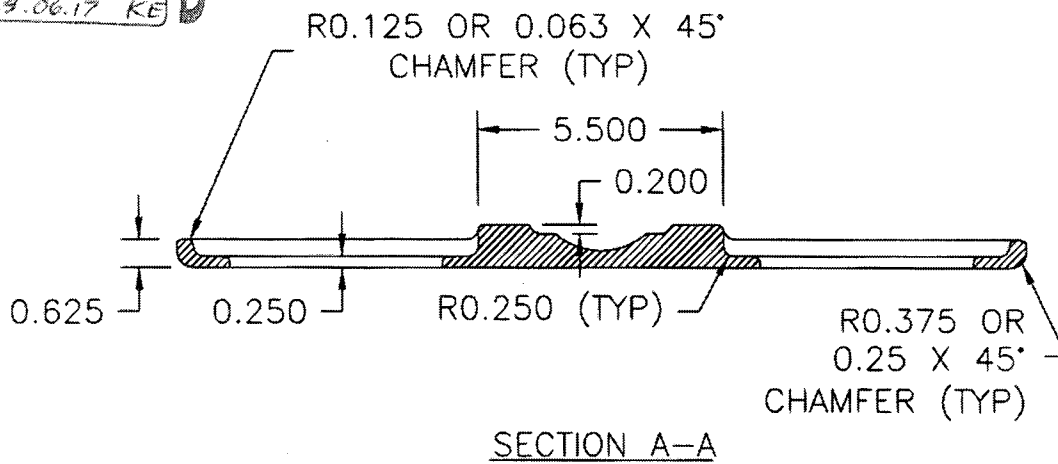
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE



01052

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